

November-12-14 12:29:36 PM

126532

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/12/14 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 11/18/14 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: Process Plan: MJS Date: 14-11-12

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3183	Rev C1

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn D3183-9 Cap as per Folio FA388Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

**DAS
40
9-89**

14/11/21

Work Order ID 126532***126532***

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Item ID: D3183-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearing Assembly
Start Date: 11/12/14 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 11/18/14 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

14/12/25
MLJ 14-11-25

Picklist Print

November-12-14 12:29:35 PM

Page 1

Work Order ID: 126532

126532

Parent Item: D3183-045

D3183-045

Parent Item Name: Bearing Assembly

Start Date: 11/12/14

Required Date: 11/18/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A04.02.18New issueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3183-5		Manufactured	No			110	Each	63.0000	1	40			
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D3183-5

Bearing

14/11/25

DAS
36
9-89

Location

Loc Qty

Loc Code

ST024

63

122716

3

123111

60

40

MDEL RINR1.000

Purchased

No

130

f

61.3100

0.0333

2

MDFI RINR1 000

Delrin Round Bar 1" color: black

Location

Loc Qty

Loc Code

MAT039

61.31

m128667

1.216

m129774

1.494

m130065

10.6

m130187

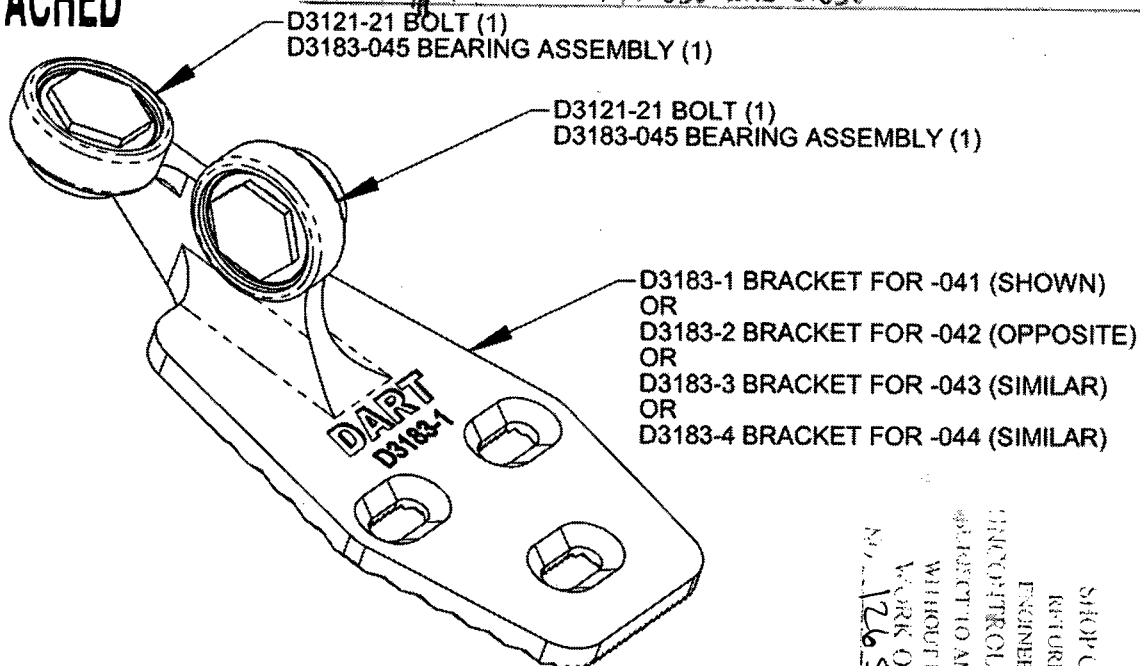
48

2 JFC 2014-11-20

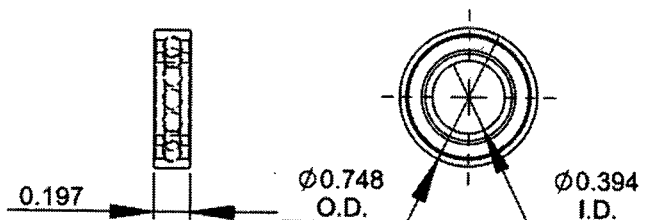


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	# 04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01
DEO ATTACHED

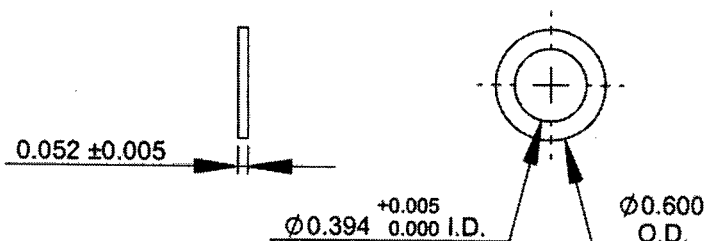


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

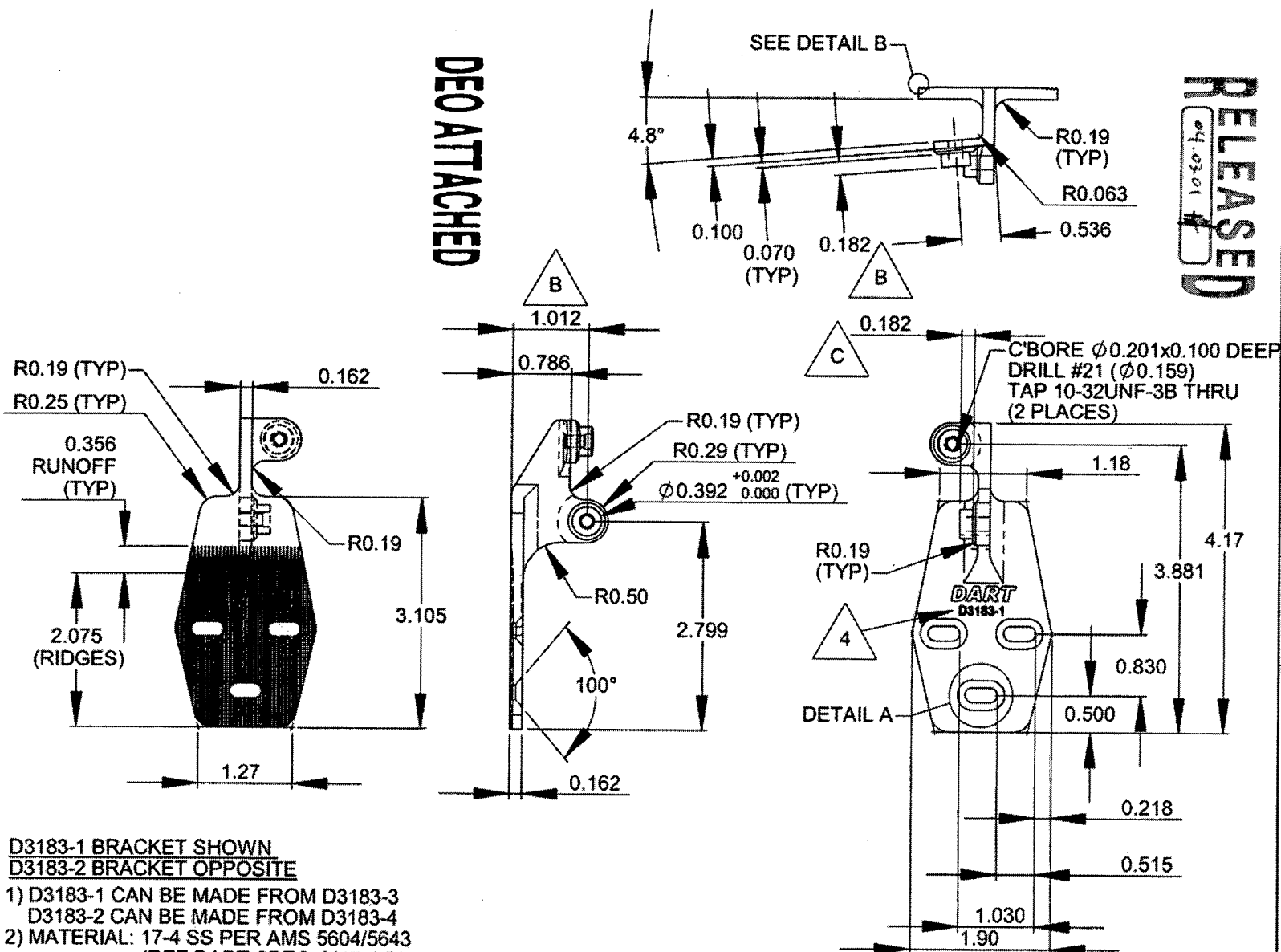
- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 2 OF 4
		SCALE 1:2

RELEASED
04.03.01**DEO ATTACHED**

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

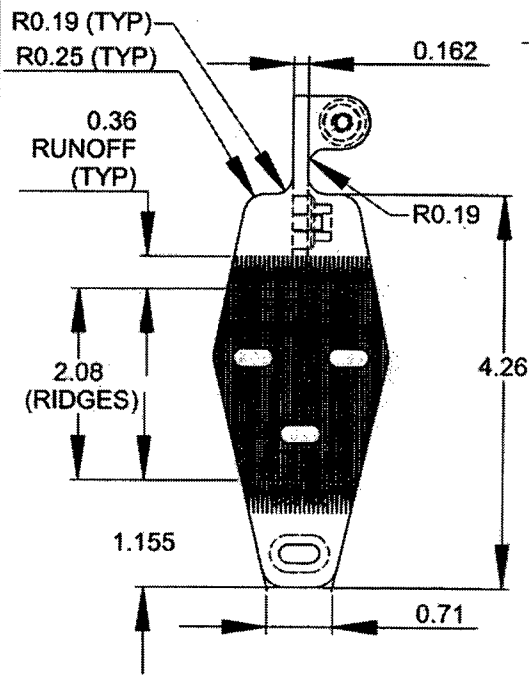
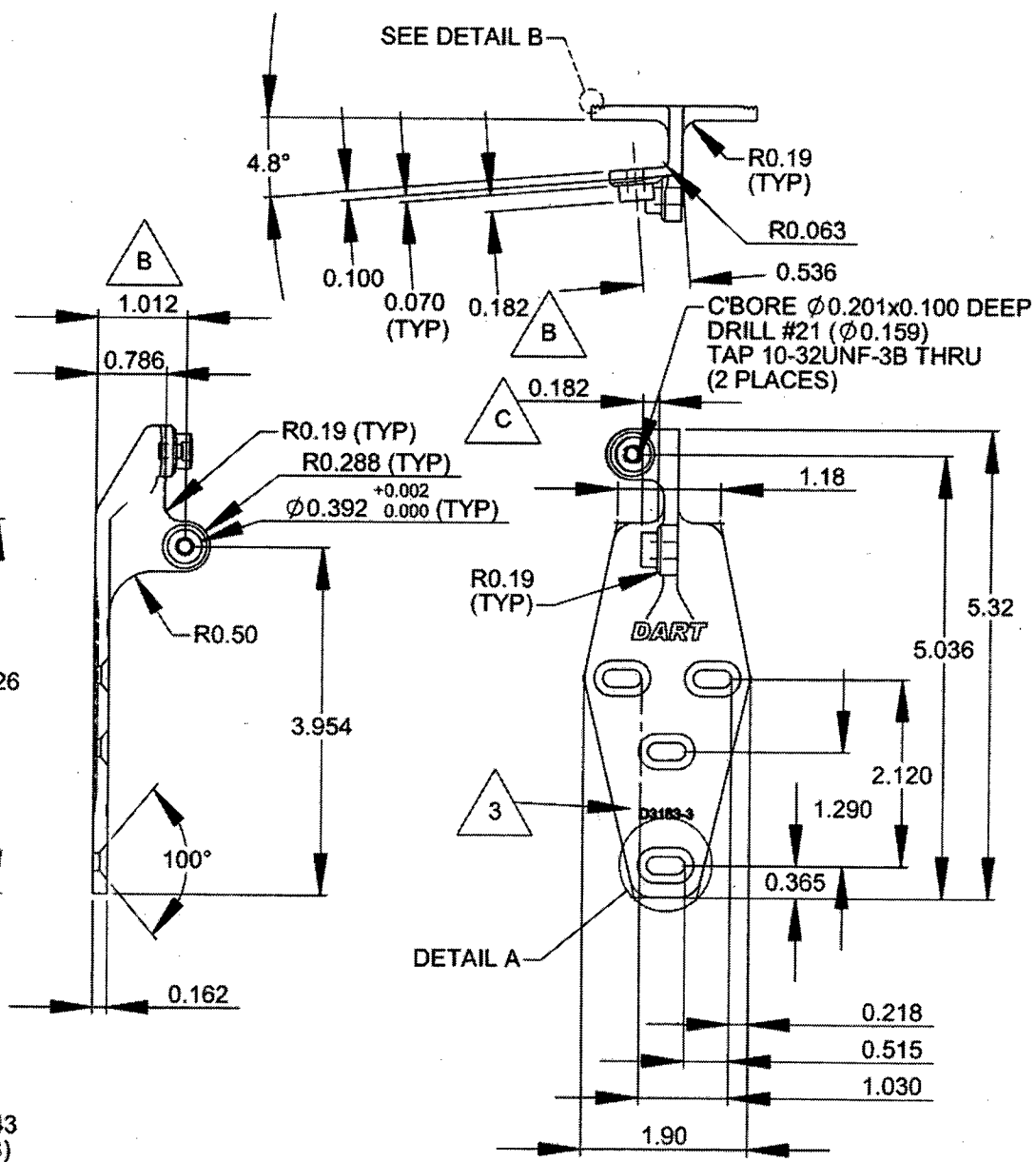
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DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE 1:2



- D3183-3 BRACKET SHOWN**
(REPLACES BELL P/N 412-030-304-105)
- D3183-4 BRACKET OPPOSITE**
(REPLACES BELL P/N 412-030-304-106)
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
 - 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 3) ENGRAVE DART P/N & LOGO AS SHOWN
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES

DEO ATTACHED

RELEASED

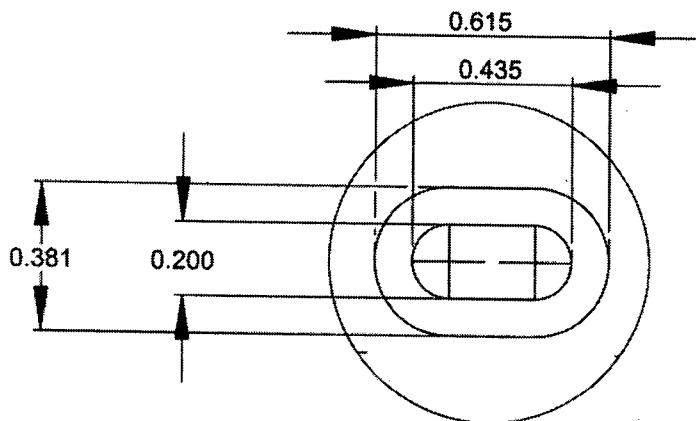
04-03-01

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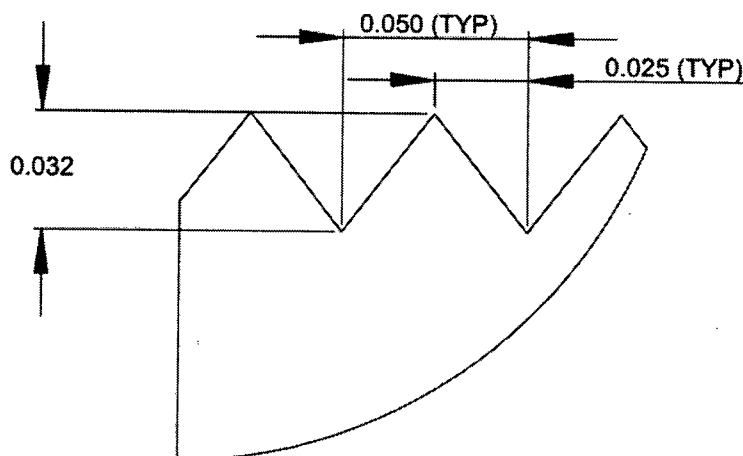
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



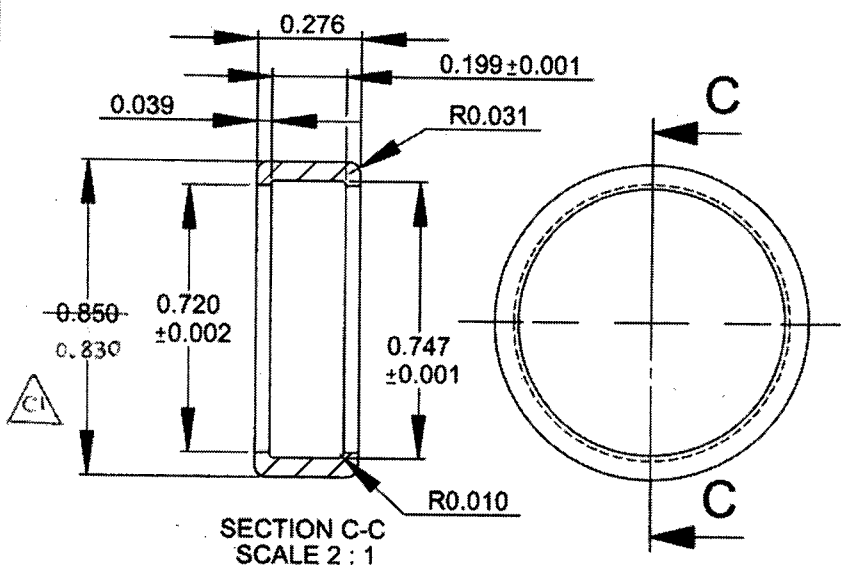
DETAIL A (2 : 1)

RELEASED
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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